

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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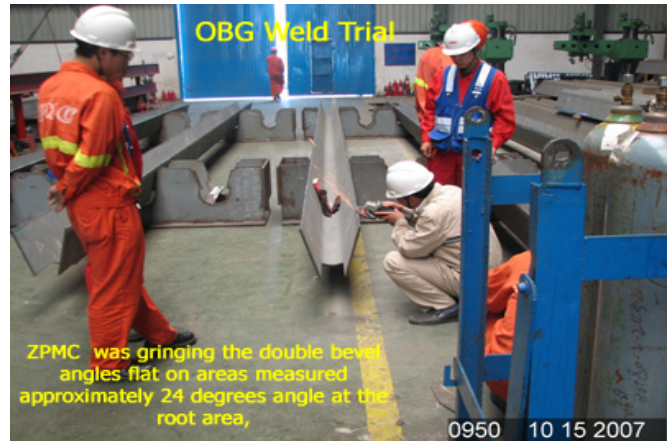
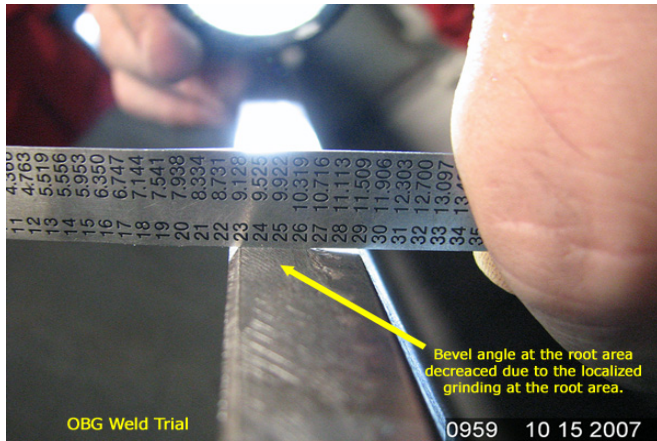
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000773**Date Inspected:** 15-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Jian Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG weld trial**Summary of Items Observed:**

CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the 10 meters U-ribs Weld Trial scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA inspector performed bevel angle verifications on the u-ribs U-70, U74, U-102,U-104 and U-71 for the OBG weld trial. The QA inspector took 22 measurements for every U-rib (110 total)at approximately 800 mm apart and approximately at the same location where ZPMC QC personnel measured the bevel angles. The QA inspector obtained bevel angles from 25 degrees and 45 minutes to a maximum of 28 degrees and 15 minutes and average bevel angle of 27 degrees. ZPMC results were similar to the results obtained by the QA inspector. However, there were several locations where the QA inspector observed that ZPMC ground the bevel with a dual angles (no flat). The photograph below shows one of the locations where the bevel angle was decreased at the root area. The QA inspector had a conversation with the ABF representatives Mr. Craig Knops and Mr. Art Peterson. The QA inspector brought to the attention to the ABF and ZPMC representatives about this issue. ZPMC agreed after rechecked the areas in question. ZPMC ground flat the areas where the bevel angles were reduced at the root areas. The photograph below shows ZPMC performing grinding operations on the surface of the bevels.

WELDING INSPECTION REPORT

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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer